

Date: Tuesday, 4/17/2007 3:56:08 PM  
 User: Kim Johnston

## Process Sheet

|   |                               |
|---|-------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services        | Drawing Name : WEAR PLATE     |
| Job Number : 31919                                    |                               |
| Estimate Number : 11231                               |                               |
| P.O. Number : <u>N/A</u>                              | Part Number : D2348           |
| This Issue : 4/17/2007 S.O. No. : <u>N/A</u>          | Drawing Number : D2348 REV B2 |
| Prsht Rev. : NC                                       | Project Number : N/A          |
| First Issue : <u>N/A</u> Type : SMALL /MED FAB        | Drawing Revision : B2         |
| Previous Run : 27736                                  | Material : <u>N/A</u>         |
| Written By : <u>Hj07.04.18</u>                        | Due Date : 5/20/2007          |
| Checked & Approved By : <u>Hj07.04.18</u>             | Qty: <u>53</u> Um: Each       |
| Comment : Est Rev A Removed from 9 Digit 05-12-05 JLM |                               |
| Est Rev:B Now on Waterjet 06-07-03 JLM                |                               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M6061T6S063 | 6061-T6 .063 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
 (M6061T6S.063)  
 Batch: M19326

SAP 07/05/09

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2348  
 Dwg Rev: B2  
 Prog Rev: B2

SAP 07/05/09

53

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/05/09

53

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SAP 07/05/09

53

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|







Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

SAP 07/05/09

X53

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |  |                                 |                 |   |  |   |
|----------|------|---|--|---------------------------------|-----------------|---|--|---|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B  |                                 |                 | Verification<br>Section C   | Approval<br>Chief Eng  | Approval<br>QC Inspector  |
|          |      |   | Initial<br>Chief Eng   | Action Description<br>Chief Eng | Sign &<br>Date  |   |  |   |
| 07/05/09 | 2.0  | 2 part Scrap need to change<br>offset on machine from 0.015<br>to 0.013 | <br>GS1042 | Scrap - destroy replace         | SAD<br>07/05/09 | <br>07/05/09 | <br>GS1042 | <br>07/05/09 |
|          |      |   |  |                                 |                 |   |  |   |
|          |      |   |  |                                 |                 |   |  |   |

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:08 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 31919

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/09 (53)

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: 3741

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

C 07/05/10

(53)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

C 7/5/18 (53)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
INSPECT CERTS

0705.23  
counted 53

10.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert

M104192-X

m101634 X13

07/05/23 (53)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

07/05/24

ml (X 53)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/24 (53)

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/03/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 31919

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 30

*07/15/04*

*(53)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



*(53)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/15/05*

Job Completion



*Le 07.25*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



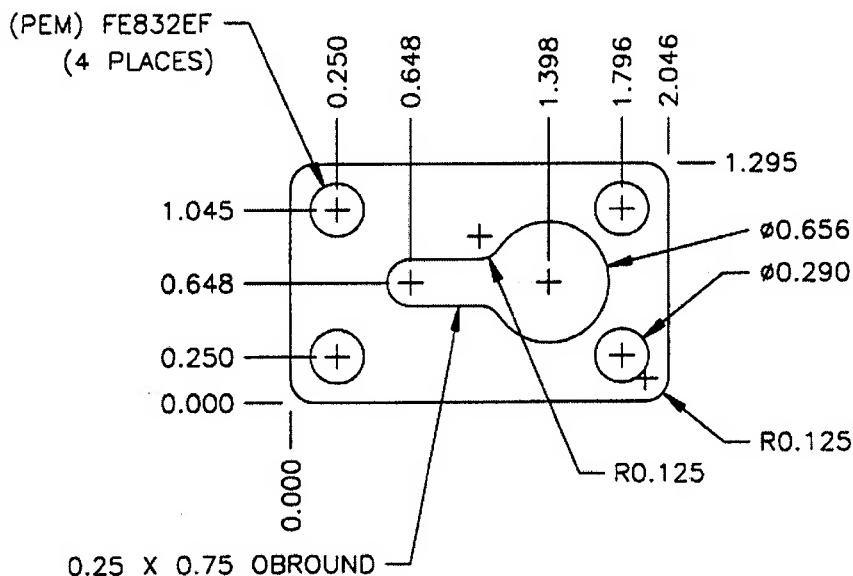




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|            |  |             |  |  |  |
|------------|--|-------------|--|--|--|
| DESIGN     |  | DRAWN BY    |  | DART AEROSPACE LTD                     |  |
| B WILLIAMS |  | B WILLIAMS  |  | VICTORIA INTERNATIONAL AIRPORT, CANADA |  |
| CHECKED    |  | APPROVED    |  | DRAWING NO.                            |  |
| D.W.       |  | [Signature] |  | D2348                                  |  |
| DATE       |  | TITLE       |  | REV. B                                 |  |
| 95:01:20   |  | WEAR PLATE  |  | SHEET 1 OF 1                           |  |
| B          |  | 95:02:20    |  | CHANGED PEM INSERT TO 8-32             |  |
| B1         |  | 00.03.07    |  | CHANGE TO AISI 304/316 MATERIAL        |  |
| B2         |  | 02.02.21    |  | CHANGE BACK TO 6061-T6                 |  |

RELEASED  
97/04/22 DS



- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
  - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II/IB CLASS 2
  - 3) INSTALL F832 EF INSERTS AFTER ANODIZING
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) TOLERANCES ARE PER PART QSF. 01B UNLESS OTHERWISE NOTED.
- UNC

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31919

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK  
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~



TNM

# ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2  
 Telephone: (514) 429-7777 Fax: (514) 429-5108  
 Certifié ISO 9001-2000 / AS9100 certified  
 approuvé NADCAP approved

C. OF C

55318

17-May-2007

## CLIENT / CUSTOMER:

**DART AEROSPACE LTD.**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ONTARIO  
 K6A 1K7

## CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

**PURCHASE ORDER/  
 NO. DE COMMANDE:** 00003741



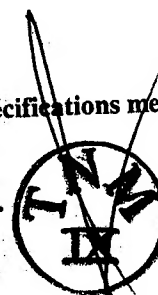
| ITEM | COMMANDE ORDERED | EXPEDIE SHIPPED | PART NUMBER & DESCRIPTION | PART PROCESS & TREATMENT                                |
|------|------------------|-----------------|---------------------------|---|
| 1    | 53               | 53              | D2348 B31919              | BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER |

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

counted 53

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
 Travel cards have been filed and are available for viewing upon request.



Signature/Signed: \_\_\_\_\_

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐

**TNM****ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE  
INVOICE****55318**

17-May-2007

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/  
NO. DE COMMANDE: 00003741****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

| ITEM                     | COMMANDE<br>ORDERED | EXPEDIE<br>SHIPPED | PART NUMBER & DESCRIPTION |        | PREX UNITAIRE<br>UNIT PRICE | EXTENSION |
|--------------------------|---------------------|--------------------|---------------------------|--------|-----------------------------|-----------|
| 1                        | 53                  | 53                 | D2348                     | B31919 | \$3.60                      | \$190.80  |
| <b>SUB TOTAL:</b>        |                     |                    |                           |        |                             | \$190.80  |
| <b>TPS/GST:</b>          |                     |                    |                           |        |                             | \$11.45   |
| <b>TVQ/PST:</b>          |                     |                    |                           |        |                             | \$0.00    |
| <b>TOTAL AMOUNT DUE:</b> |                     |                    |                           |        |                             | \$202.25  |

**UNIT PRICE TO BE APPLIED**

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

**CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE  
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

*En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.*

*Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the value of the parts.*